

What is claimed is:

1. A numerical controller for performing a superposing control to control motion of a slave axis parallel to a master axis for moving a workpiece, by a superposed motion command obtained by superposing a motion command for the master axis on a motion command for the slave axis, comprising:

means for receiving a slave-axis motion suspending command commanded by a program or an inputted signal in the superposing control; and

means for suspending the motion of the slave axis and subtracting an amount of the motion command for the master axis from a coordinate value of the slave axis in a workpiece coordinate system set to the workpiece when the slave-axis motion suspending command is received.

2. A numerical controller according to claim 1, further comprising:

means for receiving a slave-axis motion resuming command commanded by the program or an inputted signal; and

means for resuming the motion of the slave axis so that the superposing control is resumed when the slave-axis motion resuming command is received.